

SPUT

Dart Aerospace Ltd.

Date: Monday, 18/08/2008 10:26:53 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 41287

Estimate Number : 12882

P.O. Number :

This Issue : 18/08/2008

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Previous Run : 35404

Written By :

Checked & Approved By :

Comment :

: JUL 08 8.18
: Est Rev:A New Issue 07.05.24 EC

est rev B ECN 987 07.10.09 EC verified by: DD

Est Rev:C ECN1048 07-12-18 DD verified by: EC

Drawing Name : ARM

Part Number : D3560042

Drawing Number : D3560 REV D

Project Number : N/A

Drawing Revision : D

Material :

Due Date : 10/09/2008

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X05000

6061-T6 Bar .500 x 5.00



Comment: Qty.: 1.4648 f(s)/Unit Total: 14.6475 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M109025 not in computer

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41287

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/07/02 (10)

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE

B 42279

SP 08.10.01 (3X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch (65 deg C) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.10.01

P70

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-10-01 (2)

1000

1000

1000

1000

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41287

Part Number: D3560042

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



M 08-10-02 (2) *2X*
M 08/09/17

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



JW *FD* 08/10/02 (2)
08-09-17 (X2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 D2808 Bushing



337113 (2)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
Spacer

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



337113 08/10/02 08/09/18
08/10/02 (2) *08/09/18* (2)

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Press bushing in D3560 arm per dwg D3562

14.0 QC5 INSPECT WORK TO CURRENT STEP



508/10/02 (2) *508/09/18* (2)

Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1 PACKAGING RESOURCE #1



152 *8/10/02* (2) *8/9/18*
508/10/02 (2) *508/09/18* (2)

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *152*

16.0 QC21 FINAL INSPECTION/W/O RELEASE



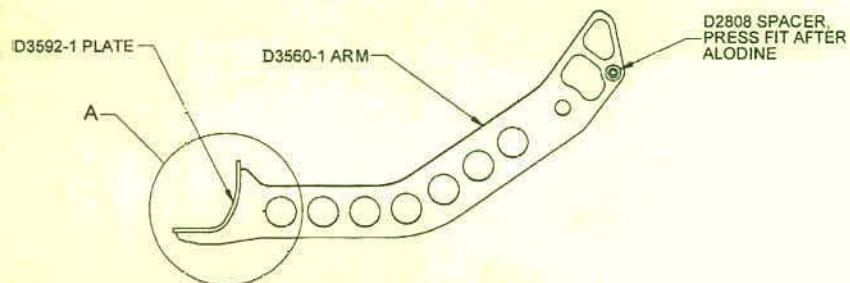
08/10/03 *08/09/19*
u 08.10.03

Comment: FINAL INSPECTION/W/O RELEASE

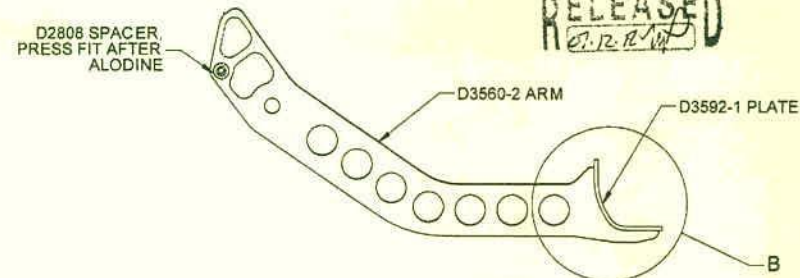
Job Completion



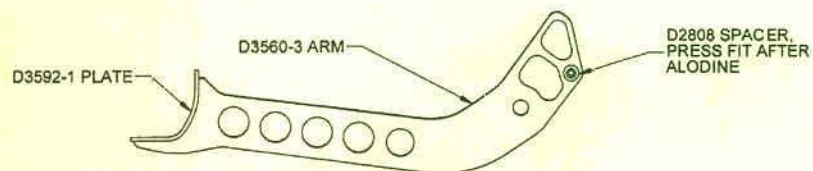
RELEASED
07.12.16



D3560-041 ARM WELDMENT



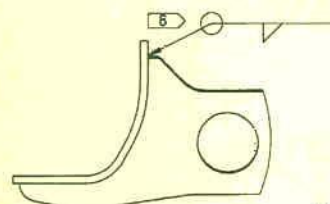
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



DETAIL A
SCALE 1 : 2

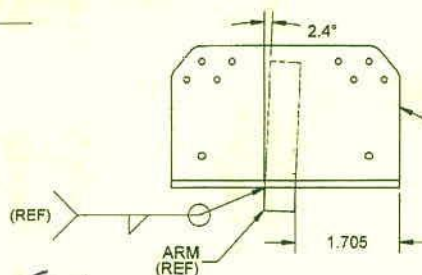
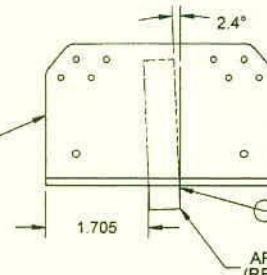
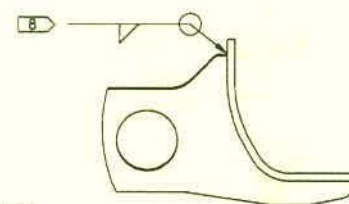


PLATE
(REF)



ARM
(REF)



DETAIL B
SCALE 1 : 2

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3560 TITLE ARM WELDMENT REV. D SHEET 1 OF 5 SCALE 1:4 <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

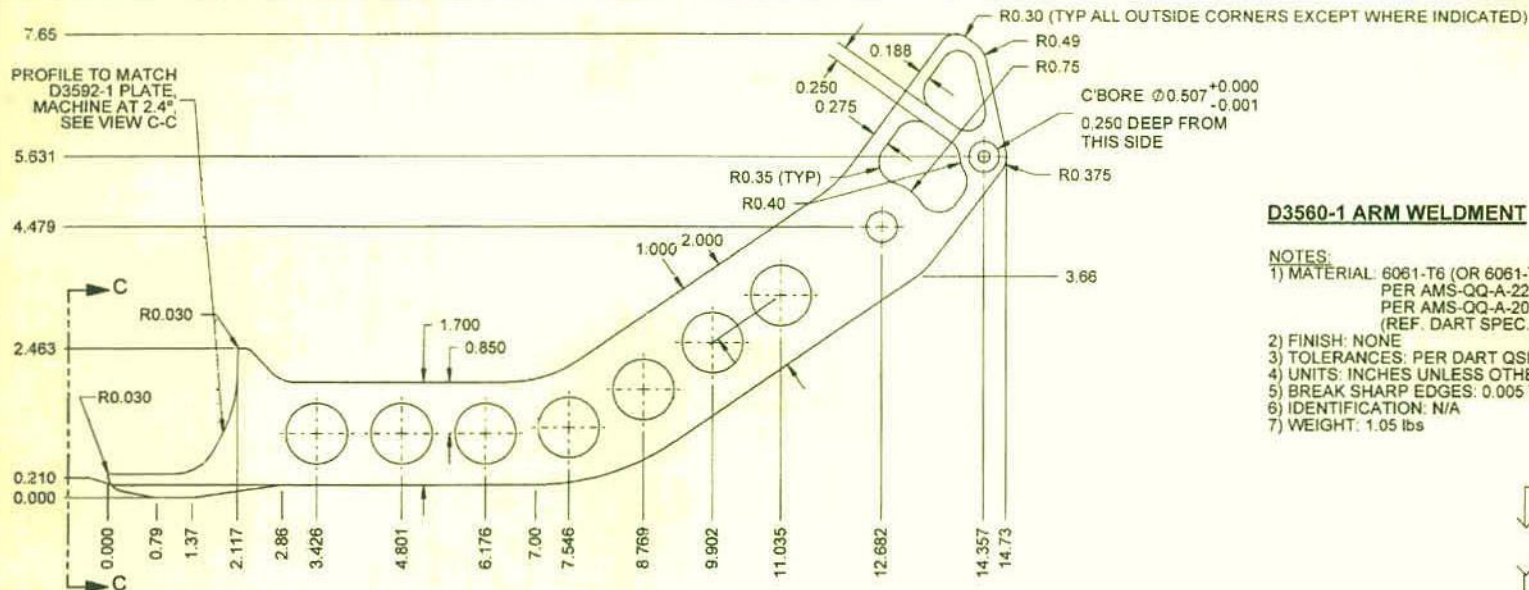
6641287

1. The first part of the report is a description of the project and its objectives. It includes a brief history of the project and a statement of the problem to be solved. The second part is a description of the methodology used in the study. This includes a description of the data collection methods and the statistical methods used to analyze the data. The third part is a description of the results of the study. This includes a description of the findings and a discussion of their implications. The fourth part is a conclusion and a list of references.

1994

1994

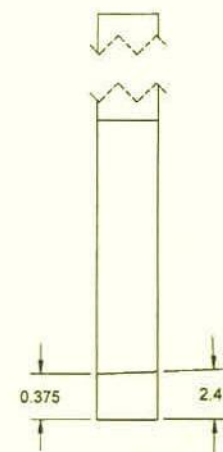
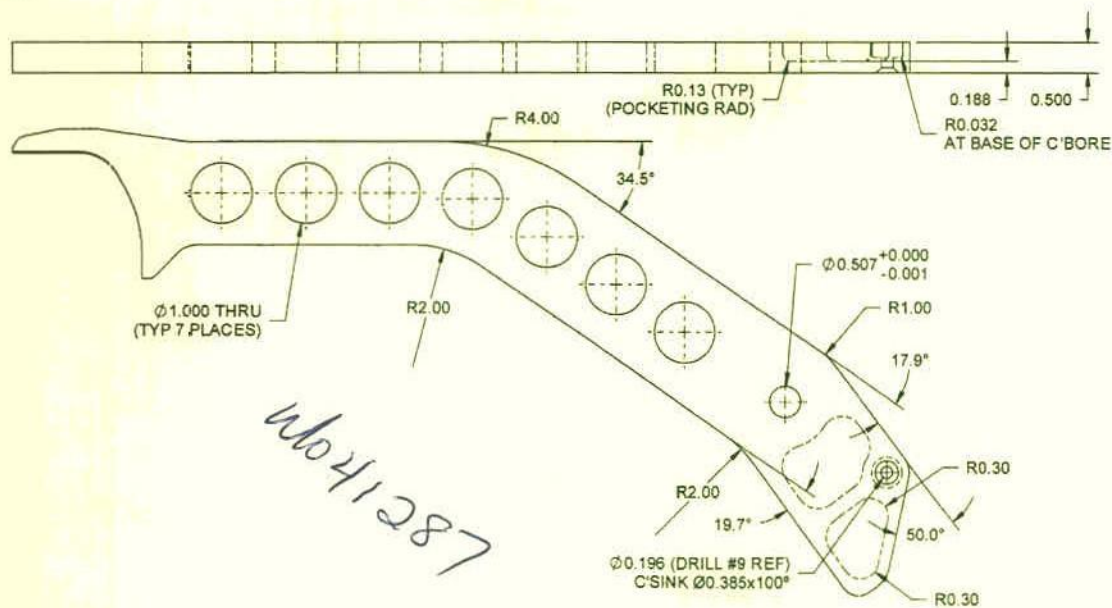
1994



D3560-1 ARM WELDMENT

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

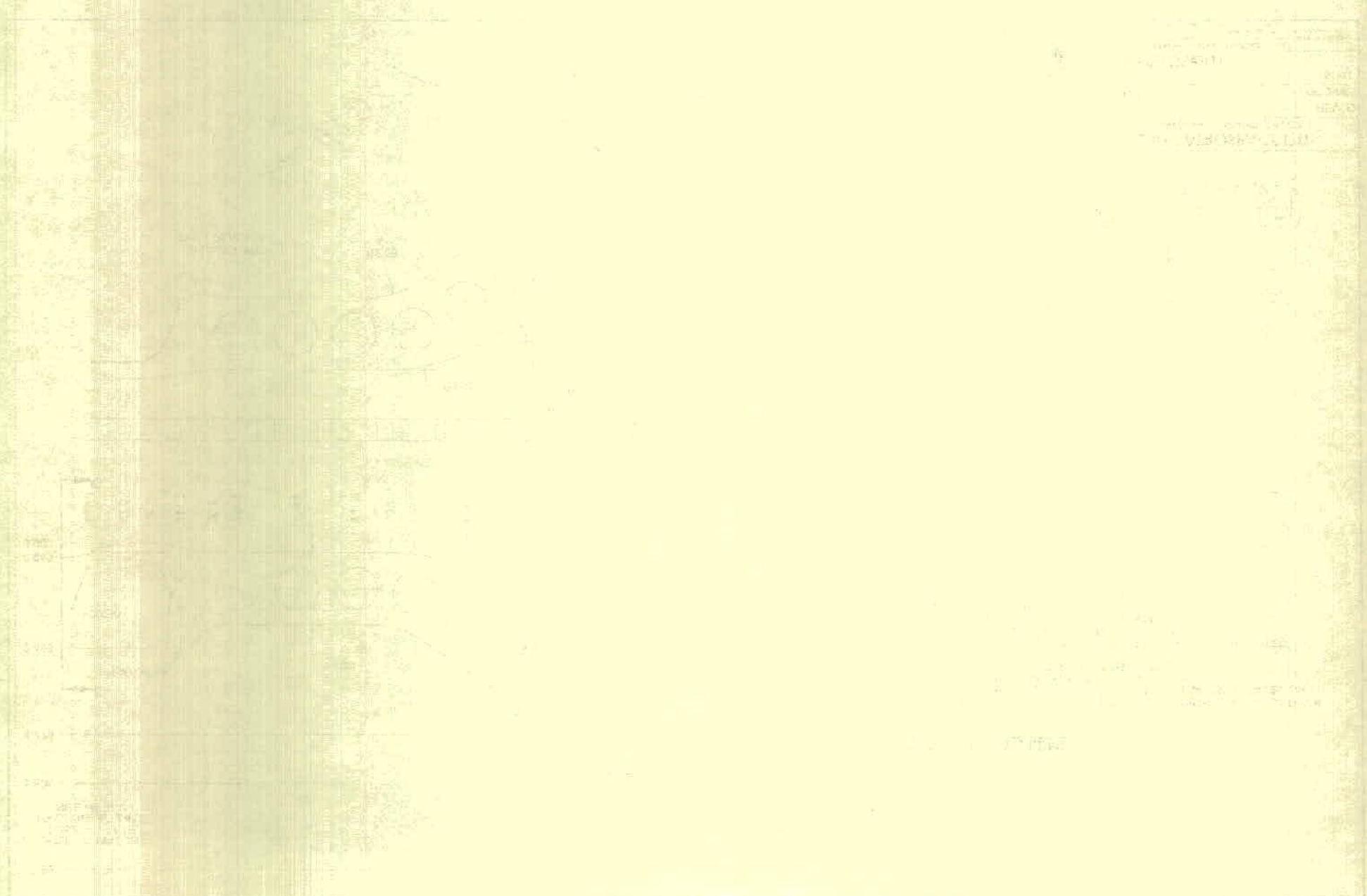


VIEW C-C
SCALE 1:1

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07.12.11

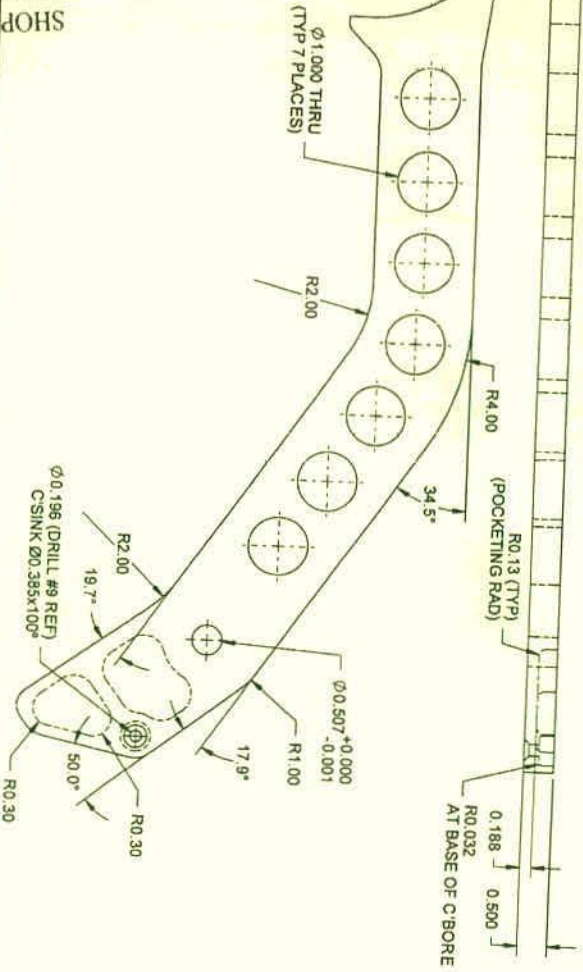
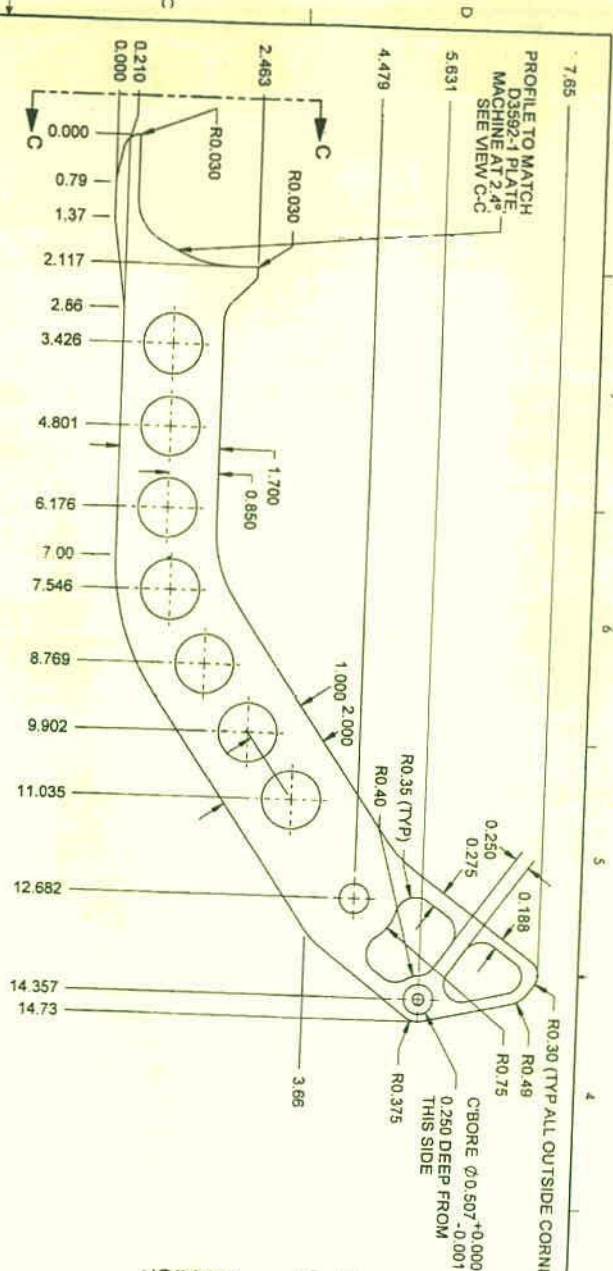
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MFG. APPR.	<i>g</i>	D3560	SHEET 2 OF 5
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>g</i>	ARM WELDMENT	1:2
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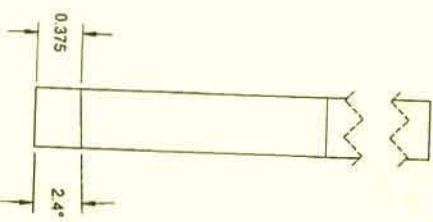
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NO. 44287
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D3560-1 ARM WELDMENT

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/7651/762) BAR, 0.500 THICK PER AMS-QQ-A-2258 (OR AMS 4117/4128/4154/16) OR PER AMS-QQ-A-2008 (OR AMS 4160) (REF: DART SPEC. M6061T650.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs

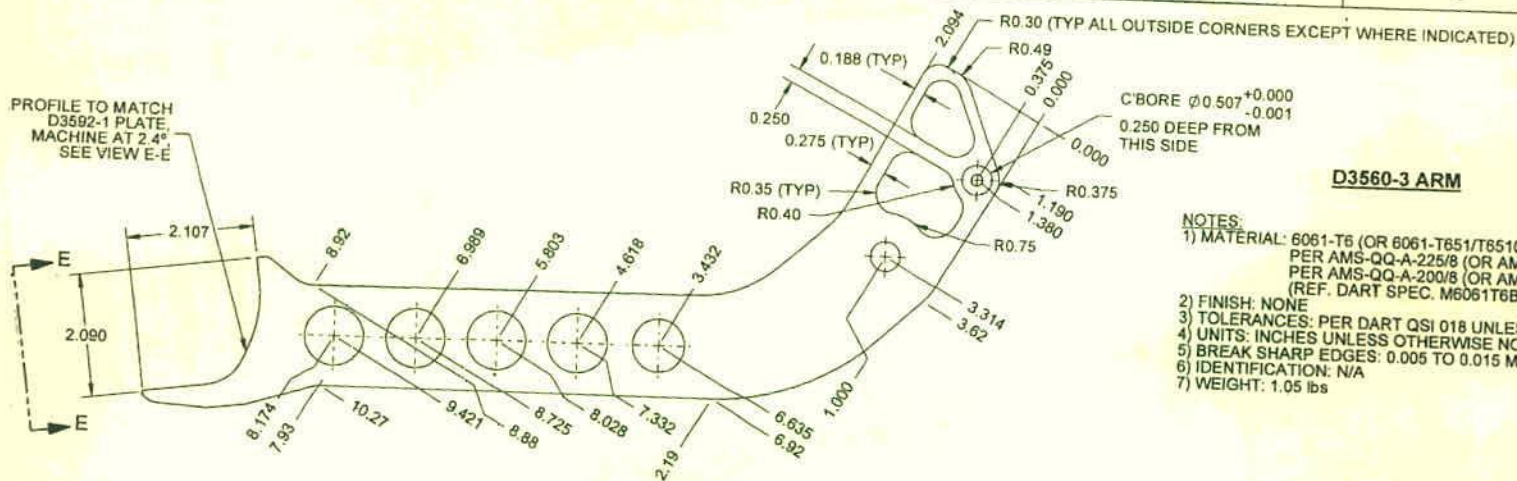


VIEW C-C
SCALE 1:1

RELEASED
07/12/2008

DESIGN	01	DART AEROSPACE LTD
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MFG. APPR.	JK	
APPROVED	JK	
DATE	07.11.16	
TITLE	ARM WELDMENT	
SCALE	1:2	

PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW E-E



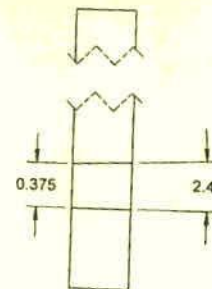
D3560-3 ARM

NOTES:

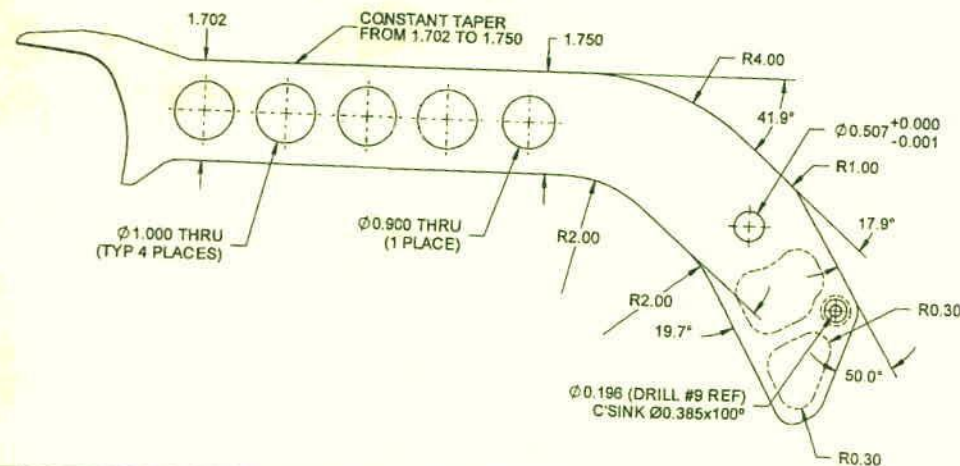
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

R0.13 (TYP)
(POCKETING RAD)

R0.032
AT BASE OF C'BORE



VIEW E-E
SCALE 1:1




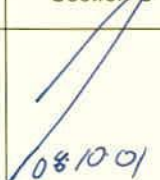


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67-12-14/50

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MFG. APPR.	h	D3560	SHEET 4 OF 5
APPROVED	MD	TITLE	SCALE
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NO. 41287
WORK ORDER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-042 PAR #: N/A Fault Category: Eng / ~~Des~~ Drawings NCR: Yes ☐ No ☒ DQA: D Date: 08/10/06
 Resolution: Scrap Disposition: SCRAP QA: N/C Closed: _____ Date: _____

NCR: <u>41287</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-01	7.0	1 part cracked after welding. R.C: Tricky process		Scrap; destr. See CAR 08-026	SAD 08/10/01			

NOTE: Date & initial all entries

100-200

40

100-200

100-200

100-200

200

100-200

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